

Date: Monday, 4/24/2006 10:24:54 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LUG
Job Number	: 26757		
Estimate Number	: 10337		
P.O. Number	: N/A	Part Number	: D28073
This Issue	: 4/24/2006	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D2807 REV C
First Issue	: N/A	Project Number	: N/A
Previous Run	: 26647	Drawing Revision	: C
	Type : MACHINED PARTS	Material	: N/A
Written By	: <u>SEE COMMENT BELOW</u>	Due Date	: 5/8/2006
Checked & Approved By	: <u>06.04.24</u>	Qty:	40 Um: Each
Comment	: Est A 05.06.02 New Issue KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M303R0750	303 Round Bar .75"
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Comment: Qty.: 0.1094 f(s)/Unit Total: 4.3764 f(s)
Material: 303 Round Bar Ø0.750"
(M303R0.750)

Batch: M100806

M8 06/05/27

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE
Turn as per Folio FA529 and Dwg D2807 Dwg Rev: C

2-Deburr

M8 06/05/27 40

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

M8 06/05/27 40

4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: Haas #1
Machine as per Folio FA528 and Dwg D2807 Dwg Rev: N/A Machined Manually
Folio Rev: 06/05/30

2-Deburr

06/05/30 40

5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

06/05/30 40

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 18 Date: 06/05/31
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 4/24/2006 10:24:54 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG

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Part Number: D28073

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SA 06.05.30

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST321

AL 06/05/30 40

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Doc 06/05/31 (40)

Job Completion



AL 0605-31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

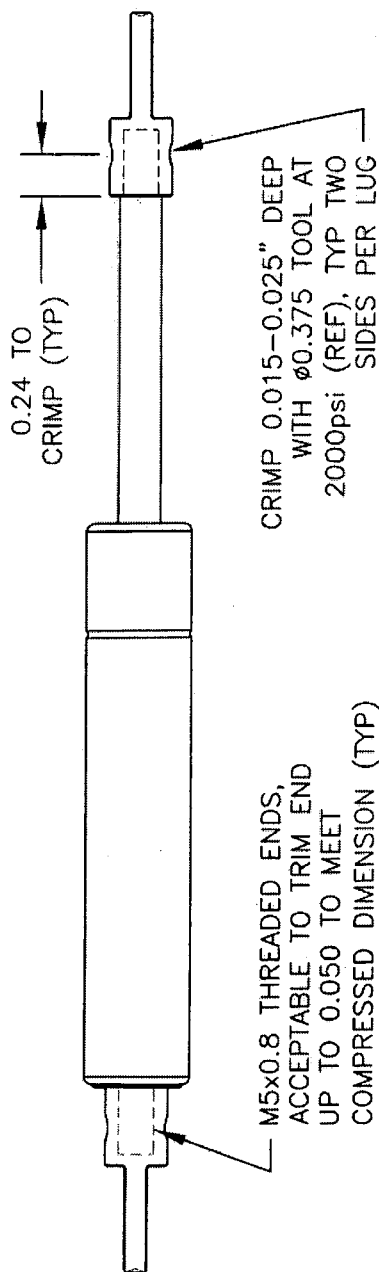
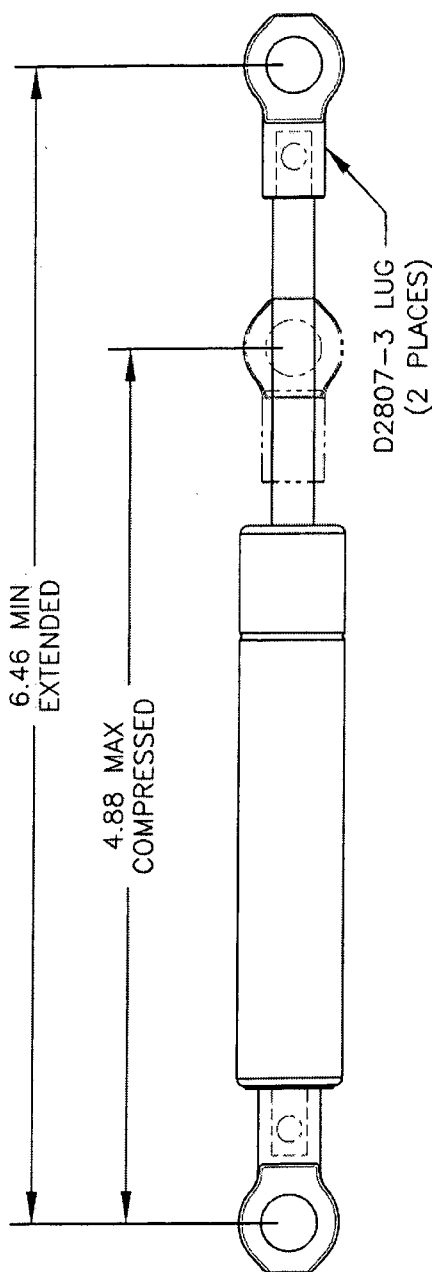
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD
				HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D2807
				REV. C SHEET 1 OF 2
DATE	05.05.25	TITLE	GAS SPRING	SCALE 1:1
A	00.11.03	NEW ISSUE		
B	05.03.16	ADD FINISH		
C	05.05.25	CHANGE SPRING TO SS, ADD -3 LUG		

RELEASED
#05.06.16



D2807 GAS SPRING

1) SPECIFICATION: SS GAS SPRING

ACCEPTABLE LOAD RANGE IS 25 lb MIN TO 45 lb MAX
M5x0.8 THREADS

POSSIBLE SUPPLIER: ArvinMeritor Motion Control Systems, Leicester, UK
P/N: SXF6S6050080S6L-115N
(REF: 80mm LONG CYLINDER, 50mm STROKE, 115N LOAD)

POSSIBLE SUPPLIER: ArvinMeritor Motion Control Systems, Leicester, UK
P/N: SXF6S6050080S6L-115N
(REF: 80mm LONG CYLINDER, 50mm STROKE, 115N LOAD)

ALL DIMENSIONS ARE IN INCHES
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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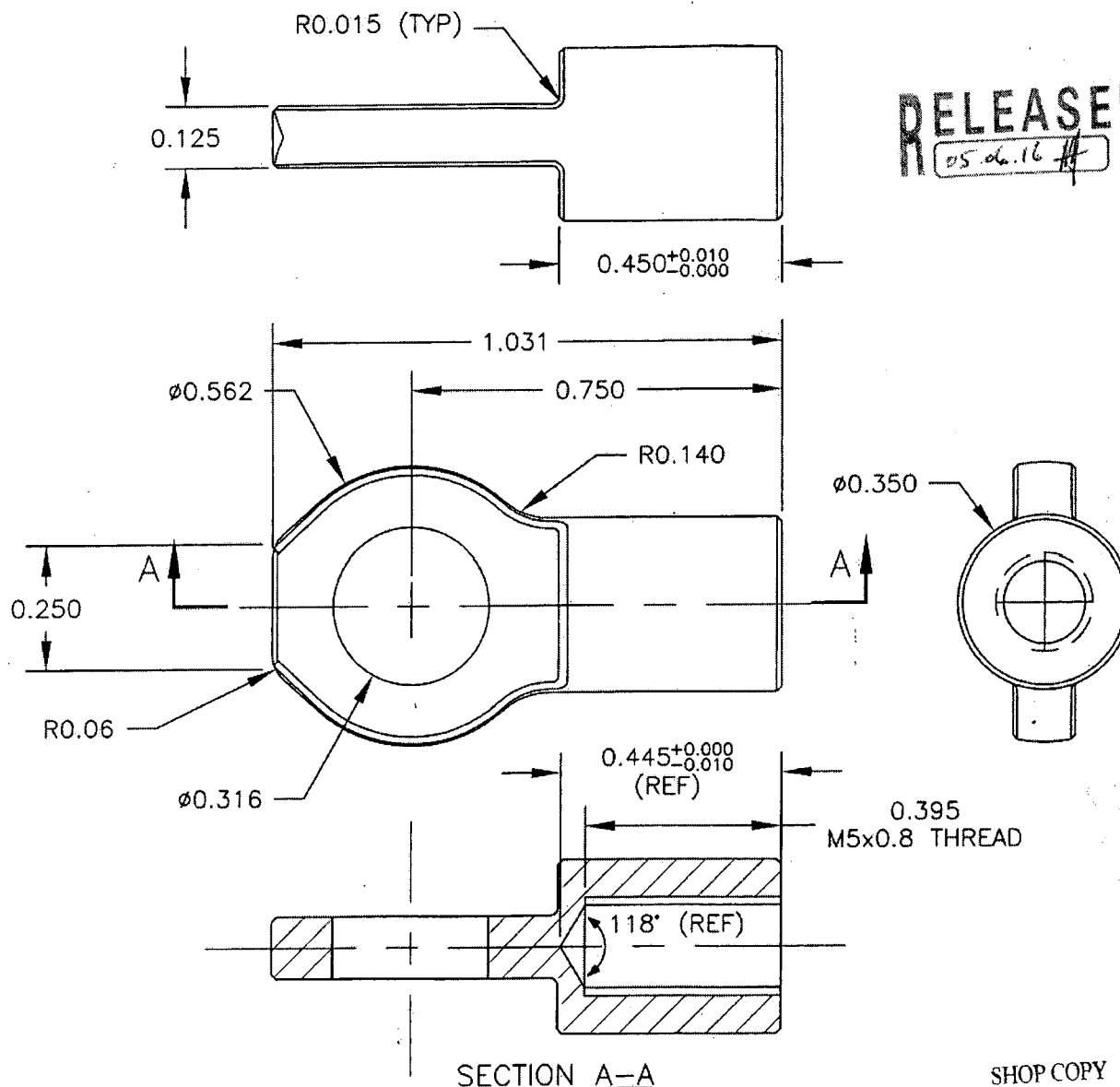
SUBJECT TO AMENDMENT

WORK ORDER

NO. 26754



DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2807	REV. C SHEET 2 OF 2
DATE 05.05.25		TITLE GAS SPRING	SCALE 3:1



D2807-3 LUG

- 1) MATERIAL: AISI 303 ROUND BAR (REF DART SPEC. M303R)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.015
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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NO. 26757

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